

Date: Tuesday, 11/03/2008 8:25:45 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 37762		
Estimate Number	: 13168		
P.O. Number	:	Part Number	: D37411
This Issue	: 11/03/2008 S.O. No. :	Drawing Number	: D3741 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: <i>134/08-03-12</i>
Previous Run	: 37400	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 14/03/2008 Qty: 24 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:A 08-01-30 new issue DD verified by:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

~~D6207~~ *D6203*

Angle Extrusion 1x1x.125

1.5x1.5x.125

Comment: Qty.: 0.0656 f(s)/Unit Total : 1.5750 f(s)

D6207 angle extrusion

Batch: *831395**SC 08-03-12*

2.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: 1-drill holes as per dwg D3741

2-Deburr

SC 08-03-12 24

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SC 08-03-12 24

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/03/12 24

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3741

2- Deburr if necessary

08/03/13 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 08/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/03/2008 8:25:45 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 37762

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/13 (24)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/03/13 (24X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/03/13 (24X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WH

08.03.13 24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/13 (24)

Job Completion



2008/3/13 (24)

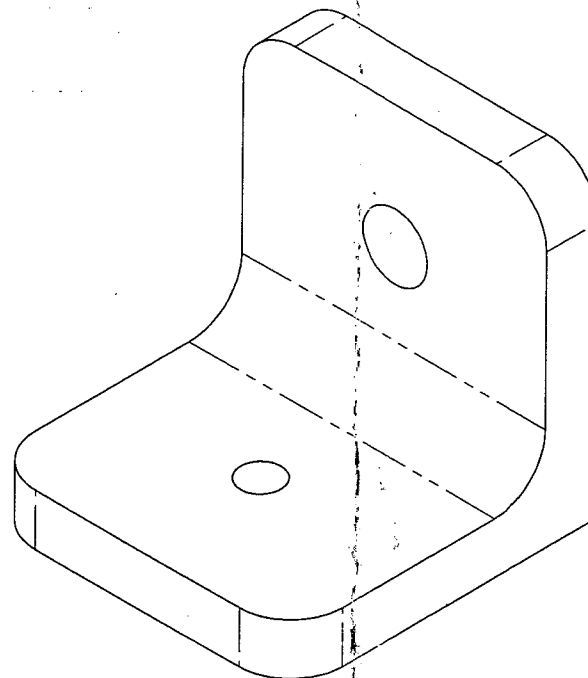
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



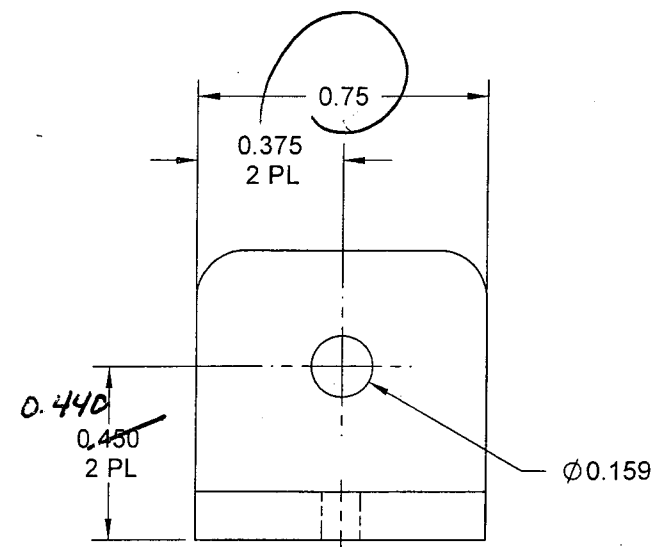
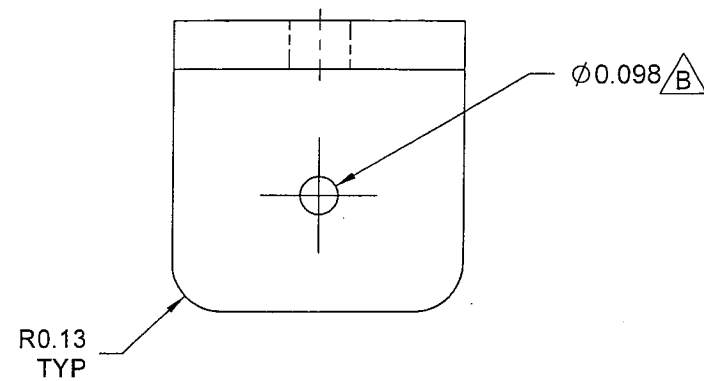
D3741-1 ANGLE

PRELIMINARY ISSUE
ASS 08.03.12

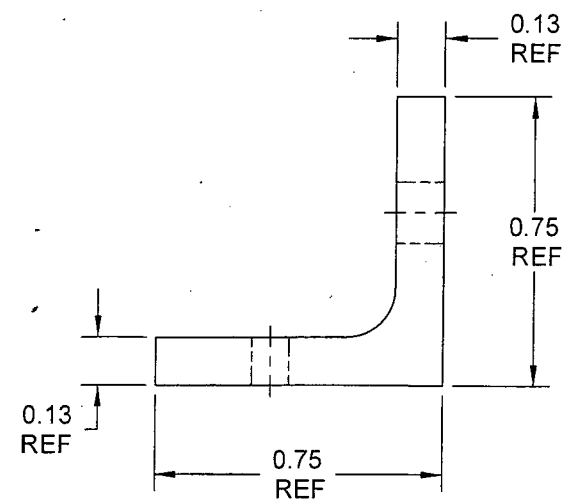
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALU MINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED.SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159.		AJS	08.03.06
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	LE	DRAWING NO.		REV. B
MFG. APPR.	MP	D3741		SHEET 1 OF 2
APPROVED	MP	TITLE		SCALE
DE APPR.	MP	ANGLE		NTS
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D3741-1 ANGLE



PRELIMINARY ISSUE

AJS 04.03.12

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	RD	D3741	SHEET 2 OF 2
APPROVED	RD	TITLE	SCALE
DE APPR.	RD	ANGLE	NTS
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FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

[illegible]

Measured by:	361	Audited by:	SA / 8/05/12	Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	